

Date: Friday, 13/02/2009 2:41:45 PM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : LUG
<b>Job Number</b> : 45802	
<b>Estimate Number</b> : 11261	
<b>P.O. Number</b> :	<b>Part Number</b> : D34143
<b>This Issue</b> : 13/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3414
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 1/1 <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 43705	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/02/2009 <b>Qty:</b> 19 <b>Um:</b> 20 <b>Each</b>
<b>Checked &amp; Approved By</b> : <u>MF 09-02-13</u>	
<b>Comment</b> : Est A 05.09.13 New issue KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304B0500X2500	304 BAR .500 x 2.50
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**Comment:** Qty.: 0.1969 f(s)/Unit Total : 2.3625 f(s)  
 304 BAR 3.94

Material: 304/316 SS Bar  
 (M304B0.500x02.500)  
 Identify for D3414-3  
 Batch: MAR 09 110253

J.L 09/02/17

20

2.0	BAND SAW	BAND SAW
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20

**Comment:** BAND SAW  
 Cut blanks: 2.50" x 0.500" x 2.250" long

J.L 09/02/17

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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19 PCU

**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA569 and Dwg D3414  
 Identify as D3414-3Dwg Rev A Folio Rev AA

J.L / H.A 09/02/20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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19

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.L / H.A 09/02/20

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

SF 09/02/21

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3414-3 PAR #: N/A Fault Category: Prod / Machine NCR: Yes No DQA: D Date: 09/02/25  
D3414-041 D206-648-013  
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/02/25

NCR: <u>45802</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/02/18	3.0	<u>1 part scrap.</u> Got out of the vise during machining due to poor material geometry. Bottom corner had a radius. R.C. Material defect.	 <u>09/02/20</u>	Have faced one side of each blanks to get a good grip.  <u>scrap; No replace.</u>	<u>B.A</u> <u>09/02/20</u>	 <u>09/02/20</u>	 <u>09/02/20</u>	 <u>09/02/20</u>

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 45802

Part Number: D34143

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Eric L.

JS 09/02/23 (x10)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



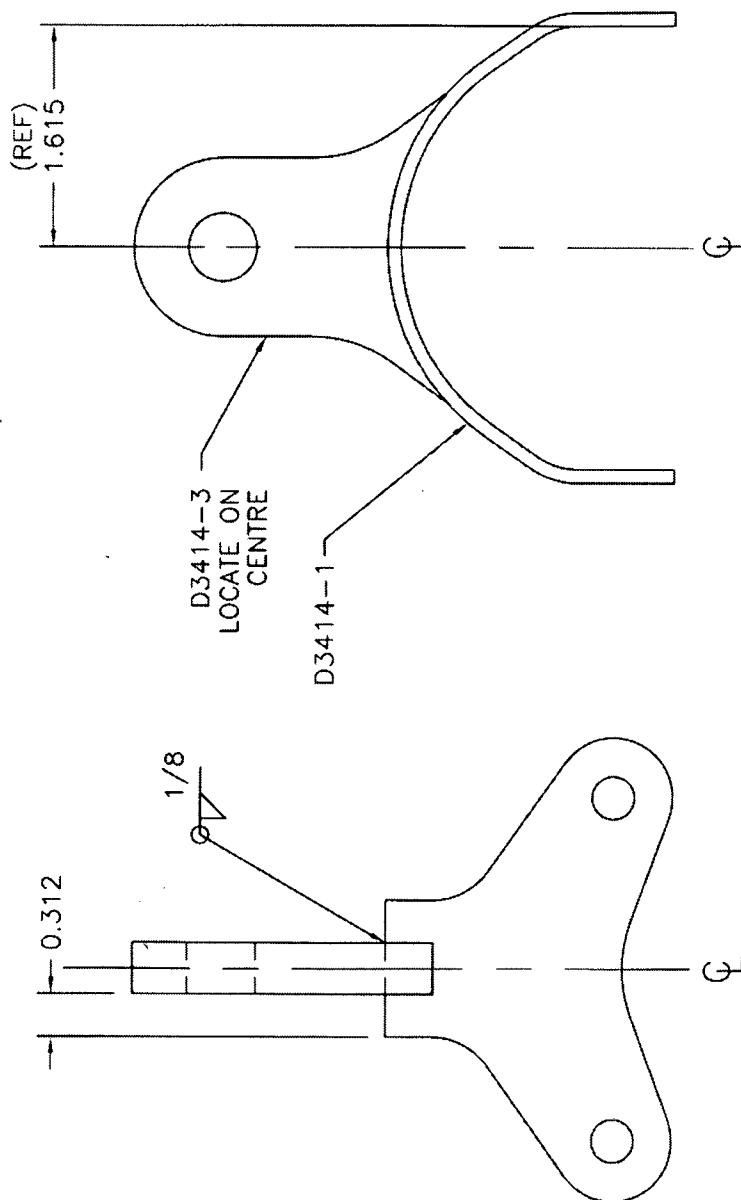
MF 09-02-23





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		PORT HADLOCK, WA			
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. A
				D3414	SHEET 1 OF 3
DATE				TITLE	SCALE
05.03.16				LUG ASSEMBLY	NTS
A	05.03.16		NEW ISSUE		

05-04-06 *[Signature]*



### **D3414-041 LUG ASSEMBLY**

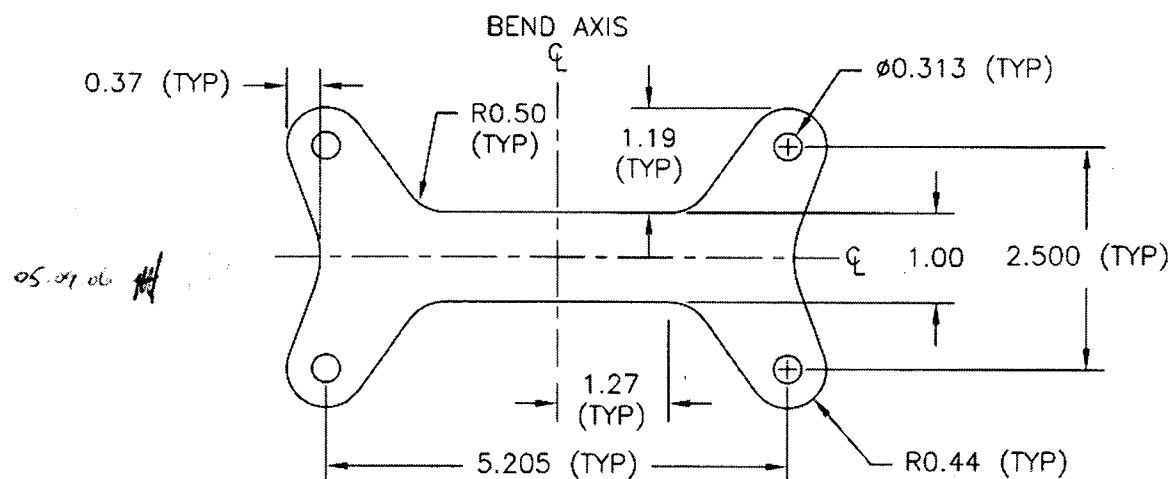
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE

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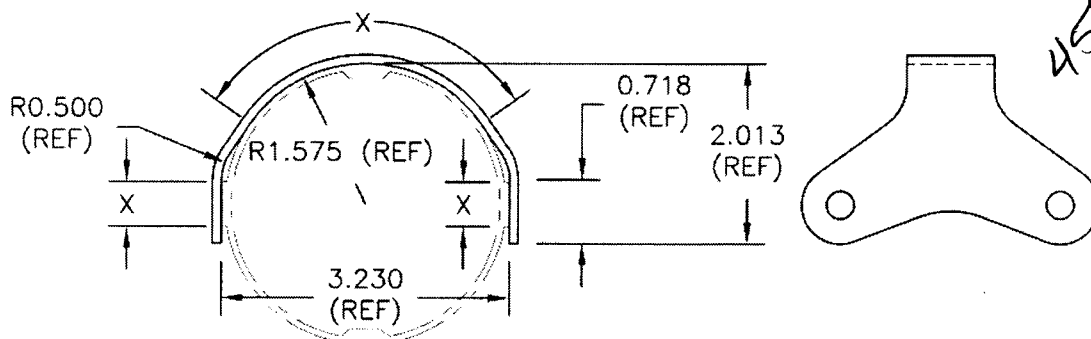
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DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 2 OF 3
DATE 05.03.16	TITLE LUG ASSEMBLY		SCALE 1:2



**D3414-1 FLAT PATTERN**  
SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)



**D3414-1 BEND DETAIL**

D3414-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

**D3414-1 LUG BRACKET**

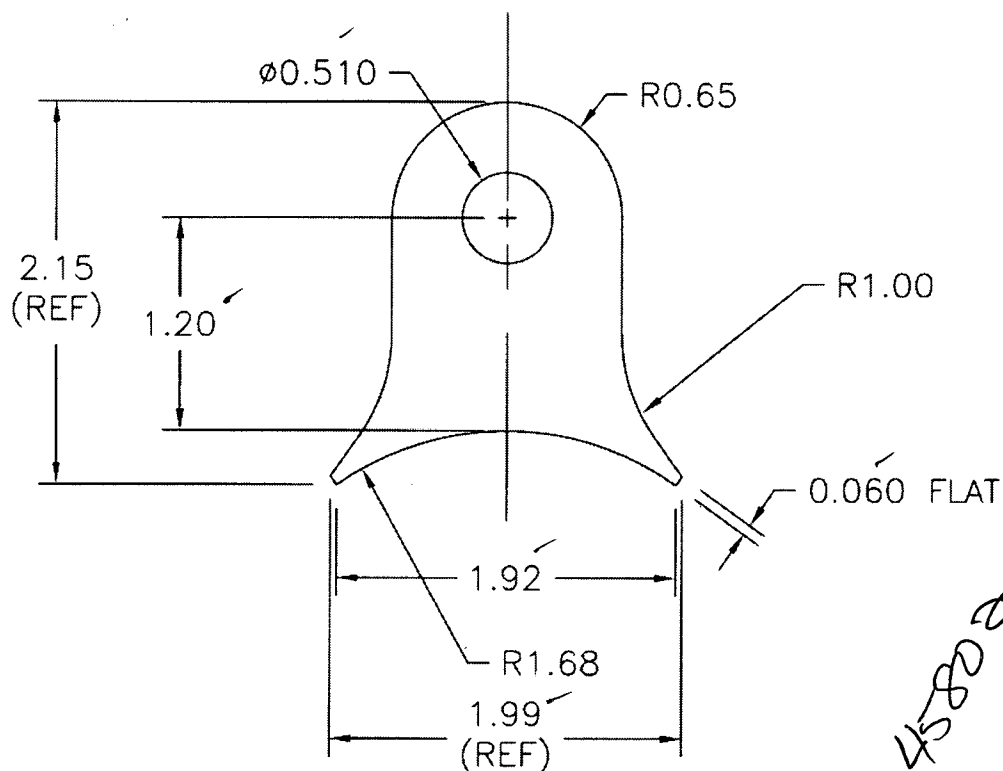
- 1) MATERIAL: AISI 304/316 SS SHEET 0.100 THICK (12 GAUGE, REF DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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				REV. A
DATE	05.03.16			SHEET 3 OF 3
				SCALE 1:1
				TITLE LUG ASSEMBLY

05-07-06 *[Signature]***D3414-3 LUG**

- 1) MATERIAL: AISI 304/316 SS PLATE 0.375 THICK (REF DART SPEC. M304S)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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